



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

U/R *SM 20/07/12*

D5805-7

Job Sheet 207483

Reprint.



POSITIVE
RECALL

Part No: D5805-7

Job Qty: 24 pcs

Part Name: Stud

POSITIVE RECALL

EFFECTIVE *20/07/12* AUTH *SM*



RELEASED _____ DATE _____

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/26/20

Job Tracking No:

Due Date: 3/27/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: URF 20-522 DWG D5805 REV.A IPP REV.A NEW ISSUE 20.01.15 JV VERF:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	24 pcs	3/27/20		0.50	1.60	Hardinge - 1		
110	QC 2	24 pcs	3/27/20		0.00	0.00	SL-154 - 1		<i>JB 20-03-07</i>
							QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		<i>JB 20-03-07</i>
							QC 2 - 83		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S261615



Part: D5805-7

Job No: 207483

Serial No/Batch: S261615

Revision: REV.A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Ends: 03/07/20

Plex 3/7/20 9:09 AM dart.auclair.guillaume

DAS
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9-89

DAS
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9-89



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EFFECTIVE _____ AUTH _____

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					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	24 pcs	3/27/20	3/27/20	0.50	1.60	Hardinge - 1		
							SL-154 - 1		JB 20-03-07
110	QC 2	24 pcs	3/27/20	3/27/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		JB 20-03-07
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S261615



Part: D5805-7

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Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/07/20

Plex 3/7/20 9:09 AM dart.auclair.guillaume

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9-89

				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
120	QC 8	24 pcs	3/27/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
130	Packaging 3-1 - Stock - B4B	24 pcs	3/27/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B

SBC 20/03/10

51191

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74
9-89

MAR 10 2020

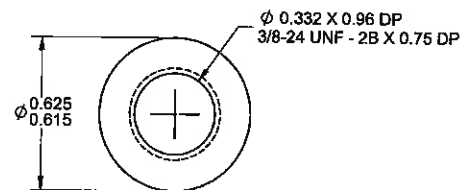
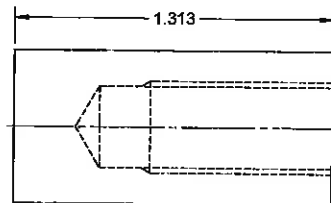
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140	QC 21 - SA	24 pcs	3/27/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op **100** - 1-Machine as per folio F_____ FOLIO REV: _____ DWG REV: A 2-Deburr
 Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - Identify as per dwg & Stock Location: _____
140 - QC21- Final Inspection - Work Order Release

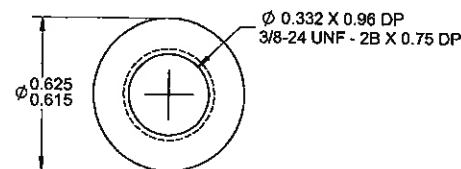
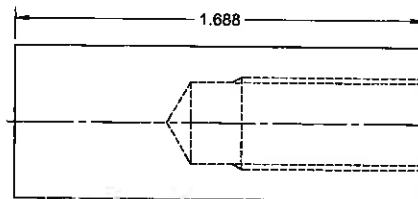
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M1018R0.625	M1018R0.625	2.9040 ft (.121 ea) <i>.122</i>	100-Hardinge - 1	<i>5000799</i>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M1018R0.625 <i>RO.450 B.A</i>	3	0	0

Part Specifications
Specifications could not be found.



D5805-7 STUD
(DERIVED FROM AERO DESIGN P/N 76423-05)



D5805-9 STUD
(DERIVED FROM AERO DESIGN P/N 76423-06)

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

NOTES:

- 1) MATERIAL: AISI 1018/1025 STEEL ROUND BAR
PER MIL-S-7097 OR ASTM A108
REF DART SPEC M1018-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.09 lbs
-9: 0.12 lbs

RELEASED
2020 FEB 18 NO

APPROVED

DESIGN	ZF	DART AEROSPACE LTD	
DRAWN	ZF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO.	REV. A
MFG. APPR.	DD	D5805	SHEET 6 OF 6
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	ATTACHMENT HOOP	NTS
DATE	20.01.13	COPYRIGHT © 2020 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Work Order:	207483
Part Number:	D5805-7
	Page 1 of 1

[illegible]

Measured by: JB	Checked by: DAS	QC Inspector:
Date: 20.03.07	Date: 57 20/03/10	Date:

Engineering Approval: (If necessary)		Date:
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Rev	Date	Change	Revised by	Approved
A	7-Mar-20	New Issue	MG	



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO37858

Supplier: ACI001-VC
Acier Ouellette Inc
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 667 4248
Fax: 450 377 5696

PO No: PC37858
PO Date: 9/25/17
Due Date: 10/6/17
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pymt Terms: net 30
Freight Terms:
Special Comments:

Line Item	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	M1018R2 250		M1018R2 250 MATERIAL: AISI 1018- 1025 ROUND BAR M1010S20GA AS PER MIL-S-7097 OR ASTM A108		Firmed	10/6/17	3 ft	0 ft	3 ft	\$12.206666/ft	\$36.62
2	M1018R0.750		M1018R0.750 MATERIAL: AISI 1018- 1025 ROUND BAR M1010S20GA AS PER MIL-S-7097 OR ASTM A108		Firmed	10/6/17	20 ft	0 ft	20 ft	\$1.169/ft	\$23.38
3	M1018B1.000X06.000		1010 1025 Steel Bar 1.000 X 6.000 MATERIAL: AISI 1010- 1025 OR ASTM A36/A366/A569/A570 OR OR CSA G40-21 38W/44W/50W/60W/70W CSA G40-21 OR 38W/44W/50W/60W/70W		Firmed	10/6/17	6 ft	0 ft	6 ft	\$30.42/ft	\$182.52
4	M304R 500		304 SS roundbar 500 MATERIAL: AISI 304/316 SS ROUND BAR AS PER ASTM A276 NOTE: AISI 303 NOT ACCEPTABLE		Firmed	10/6/17	36 ft	0 ft	36 ft	\$1.9072222/ft	\$68.66
5	M6061T6R1.375		6061-T6 Round Bar 1.375 MATERIAL: 6061- T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117 4128/4115/4116 OR QQ- AA-200/8 OR AMS QQ-A-		Firmed	10/6/17	12 ft	0 ft	12 ft	\$5.6841666/ft	\$68.21



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37858**

Purchase Order Date 9/25/2017

PO Print Date 9/25/2017

Page Number 1 of 6

Order From :

ACIER OUELLETTE INC
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

VC-4AM002

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
SEP 25 2017

Contact Name

Vendor Phone 800 667-4348

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FOA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
----------	--	------------------------	--------------------------------------	----	--------------------------------	---------------	----------------

1	M1018R2.250	M1018R2.250	10/6/2017 Yes 10/6/2017		3.00 f	\$12.21	\$36.62
---	-------------	-------------	-------------------------------	--	-----------	---------	---------

MATERIAL: AISI 1018-1025 ROUND BAR AS PER
MIL-S-7097 OR ASTM A108

Line Total: \$36.62

2	M1018R0.750	M1018R0.750	10/6/2017 Yes 10/6/2017		20.00 f	\$1.17	\$23.38
---	-------------	-------------	-------------------------------	--	------------	--------	---------

MATERIAL: AISI 1018-1025 ROUND BAR AS PER
MIL-S-7097 OR ASTM A108

recd 18.11

80171017

Line Total: \$23.38

PO Instructions: QUOTATION: 8010059234

Note:

9/25/2017



DELIVERY - CLIENT

CO00053066

ACIER OUELLETTE INC.

935, Boul. du Havre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél.: 450-377-4248 Mtl: 514-336-4248 Ext.: 000-667-4248
Fax: 450-377-5696 Mtl: 514-336-4248 Ext.: 066-456-4242

Customer N° CLI0001056
Date 2017/09/25
Delivery date 2017/10/06
Your order N° 37858
Processed by Josianne Bourdon
Salesman
Carrier OUELLETTE VALLEYFIELD
Credit Terme Net 30 Days
Page 1

Billed to

DART AEROSPACE LTD
1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to

, Ontario,

Att: CHANTAL LAVOIE Tél.: 613-632-5200

Instruction F-M

Delivery Route 5

Product Description	Weight	Qty	U/M	PCS NB			Internal Use Only				
				CHD	EXP	B/O	IN	:	S	C	OUT
1 ROUND CR 2 1/4 1018 RANDOM RCR-214-V 5301 1 X 35" HEAT: 136550 COUPE A LA SCIE SCIE: 1	40.56	3.00	PL_SCLB								
2 ROUND CR 3/4 1018 RANDOM RCR-34-V 5332 1 X 20" R/L HEAT: 139015 COUPE A LA SCIE SCIE: 1	30.00	20.00	PL_SCLB								
3 FLAT CR 1 X 6 1018 RANDOM FCR-16-V 2775 1 X 6' HEAT: 3066812	122.40	6.00	PL_SCLB								

NIR : R-109516-6

Next Page...

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 4140 RQ 750

PO / BATCH NO.: 83255/30029

DATE: OCT 18 2017

MATERIAL CERT REC'D: YES

THICKNESS ORDERED: 750

QUANTITY RECEIVED: 19'

THICKNESS RECEIVED: 750

QUANTITY INSPECTED: 19'

SHEET SIZE ORDERED: N/A

QUANTITY REJECTED: 0

SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	N	
CORRECT FINISH	Y	N	
CORROSION	Y	N	
CORRECT GRAIN DIRECTION	Y	N	
CORRECT MATERIAL PER M-DRAWING	Y	N	<u>4140 RQ 750</u>
CORRECT THICKNESS	Y	N	
PHOTO REQUIRED	Y	N	
CORRECT REF # TO LINK CERT	Y	N	<u>REF # 139625</u>
CORRECT MATERIAL IDENTIFICATION	Y	N	<u>5000799</u>
CORRECT M# ON THE MATERIAL	Y	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u>	SIGNED OFF BY: _____		
DATE: <u>OCT 18 2017</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

ARANA Y LUFANO, S
46490 UGAO-MIRAVALLIS/VIZCAYA (SPAIN)
Tfno: 946450211
Fax: 946480178
Email: alpradere@calibrededipradera.es
www.calibrededipradera.es

CERTIFICADO DE CALIDAD/QUALITY REPORT

The records are being according to:

25 JUL 1978

77

Nº CERTIFICADO: CERTIFICATE NO. 4724

ALBANY 0942 Delivery Note No.	CLIENTE LES ARMES TRANSFER (ISSA) LTD CUSTOMER
----------------------------------	---

Normo : 15 10257

Productes Col·laboració de nous Condicionants i Entorns de treball

Prishtina and produce: Technical assistance

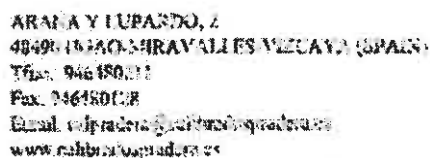
PRODOTTO SOLTENADO / PRODOT ACCORDATO 15/11/1998

[illegible]

Compressor unitaire de refroidissement : 15000 BTU/hour (4,5 kW)

[illegible]

Characteristics and Analysis / 173



De acuerdo a lo establecido en:

LN 102047 IN 5149

1

N° CERTIFICADO: CES-09-2017-0004 ATBES

Norma : EN 10277

Produtos Calibres de ar, 6 onças - 15 centos de umidade

429

Regras para o uso do Formulário de Avaliação

Valido Superficial

DESCRIPTION	QTY	Class
Description		IN 102774
1214 RED ESTIMADO 25.00 (1)	202437	3
1018 RED ESTIMADO 25.00	139291	2
1018 RED ESTIMADO 25.00	139291	2
1214 RED ESTIMADO 12.50 (1/2)	139291	2
1018 RED ESTIMADO 15.00 (50%)	139291	2
1018 RED ESTIMADO 19.05 (1/4)	139291	2
1214 RED ESTIMADO 12.50 (1/2)	139291	2
1018 RED ESTIMADO 19.05 (1/4)	139291	2
1018 RED ESTIMADO 15.00 (50%)	139291	2
1018 RED ESTIMADO 15.00 (50%)	139291	2
1018 RED ESTIMADO 19.05 (1/4)	139291	2
1018 RED ESTIMADO 22.23 (1/2)	139291	2
1214 RED ESTIMADO 15.00 (50%)	139291	2
1214 RED ESTIMADO 15.00 (1/2)	139291	2
1018 RED ESTIMADO 25.00 (1/2)	139291	2
1018 RED ESTIMADO 22.23 (1/2)	139291	2



ARANA Y ILPANDO, S
48490 UCAO-MERAVALLS/MANAYA (SPAIN)
Tfno : 946480211
Fax : 946450128
Email: calpraden@calibradospradera.es
www.calibradospradera.es

CERTIFICADO DE CALIDAD/QUALITY REPORT

De acuerdo a /According according to:

EN 10204/DIN 50049

3.1

Nº CERTIFICADO / CERTIFICATE NR : 47862

ALGARAN 47862 Delivery Note Nr.	CLIENTE LAS AGUJAS TRANSIC (007) I TEE CUSTOMER
------------------------------------	--

Norma : EN 10277

Productos Calibrados de acero. Condiciones técnicas de suministro.

Norm :

Bright steel products. Technical delivery conditions.

Observaciones: BARRAS DE ACERO ESITRADAS EN FRIO SIN ALCAR

DEPARTAMENTO DE CALIDAD: Certifica que el mencionado producto cumple con las especificaciones del p.dicho.
QUALITY DEPARTMENT: Certify that the product fulfills the order specifications.

Fecha/Date: 19.06.2017

Firmado: Susana Fernandez
Directora de Calidad



Registro de
Certificados
ISO 9001:2015

Modelo de
Certificado

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause <div style="display: flex; flex-direction: column; align-items: flex-start;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div>			
Other/Details:					